

**STAINLESS STEEL**  
**STICK ELECTRODES (SMAW)**

High recovery stainless electrode for welding ferritic-austenitic (duplex) stainless steels, e.g. UNS S31803 or similar. Also excellent for joining duplex to CMn steels.

| Specifications  |                                                                                           |
|-----------------|-------------------------------------------------------------------------------------------|
| Classifications | EN ISO 3581-A : E 22 9 3 N L R 5 3<br>SFA/AWS A5.4 : E2209-26<br>Werkstoffnummer : 1.4462 |

|                 |                     |
|-----------------|---------------------|
| Welding Current | AC, DC+             |
| Ferrite Content | FN 30-45            |
| Alloy Type      | Ferritic-Austenitic |
| Coating Type    | Acid Rutile         |

| Tensile Properties |                |                  |            |
|--------------------|----------------|------------------|------------|
| Testing Condition  | Yield Strength | Tensile Strength | Elongation |
| AWS                |                |                  |            |
| As Welded          | 645 MPa        | 800 MPa          | 25 %       |

| Charpy Testing    |              |              |
|-------------------|--------------|--------------|
| Testing Condition | Testing Temp | Impact Value |
| AWS               |              |              |
| As Welded         | 20 °C        | 50 J         |

| Typical Weld Metal Analysis % |
|-------------------------------|
| Ferrite FN                    |
| 38                            |

| Deposition Data |          |       |                  |                                    |                                          |                          |
|-----------------|----------|-------|------------------|------------------------------------|------------------------------------------|--------------------------|
| Diameter        | Amps     | Volts | Efficiency (Per) | Number of electrodes/kg weld metal | Fusion time per electrode at 90Per I max | Deposition rate at 90Per |
| 2.5 x 300.0 mm  | 60-100 A | 27 V  | 59 %             | 69                                 | 38 sec                                   | 1.4 kg/h                 |